

008171



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB 92700-10308-041

Job Sheet 190315



Part No: RB 92700-10308-041

Job Qty: 2 pcs

Part Name: Seal Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RB 92700-10308-041 Rev. A IPP Rev. A 18.07.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	3/15/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	2 pcs	3/15/19		0.00	0.00	Small Fab - 1 - B4B	EXT-LOAD B4B	AP 2019/02/27
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	2 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		

Plex 2/15/19 12:42 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen Street
Hewkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S154312



Part: RB 92700-10308-041

Job No: 190315

Serial No/Batch: S154312

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 02/15/19

130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	DAS
140	QC 21 - FG	2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	21
					QC 21 - FG - 70	9-89
					QC 21 - SA - 53	

Part Op **100** - Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1200-E	Case	2 Ea (1 ea)	100-Small Fab - 1	
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	110-Small Fab - 2 - B4B	
RB 92700-10308-041-2	Top Foam use in case APP-1200-E	2 Ea (1 ea)	110-Small Fab - 2 - B4B	
RB 92700-10308-041-3	Bottom Foam use in case APP-1200-E	2 Ea (1 ea)	110-Small Fab - 2 - B4B	
RB 92700-10308-041-4-PO	Input Module Seal Installer Assembly	2 pcs (1 ea)	110-Small Fab - 2 - B4B	
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	110-Small Fab - 2 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1200-E	2	19	0
110-Small Fab - 2 - B4B	97524A032	8	494	0
	RB 92700-10308-041-2	2	2	0
	RB 92700-10308-041-3	2	2	0
	RB 92700-10308-041-4	2	2	0
	RB41011	2	423	0
Part Specifications				
Specifications could not be found.				

Plex 2/15/19 12:42 PM Dart.Hadley.Shannon



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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RB 92700-10308-041 Job Sheet 190315



Part No: RB 92700-10308-041

Job Qty: 2 pcs

Part Name: Seal Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No: SIOP

Due Date: 3/15/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG RB 92700-10308-041 Rev. A IPP Rev. A 18.07.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Small Fab - 1	2 pcs	3/15/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
120	QC 5	2 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	2 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	2 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1200-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	110-Small Fab - 1	5145165
APP-1200-E	Case	2 Ea (1 ea)	110-Small Fab - 1	5131141
RB 92700-10308-041-2	Top Foam use in case APP-1200-E	2 Ea (1 ea)	110-Small Fab - 1	5131143
RB 92700-10308-041-3	Bottom Foam use in case APP-1200-E	2 Ea (1 ea)	110-Small Fab - 1	5131142
RB 92700-10308-041-4	Input Module Seal Installer Assembly	2 pcs (1 ea)	110-Small Fab - 1	5140665
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	110-Small Fab - 1	5021040

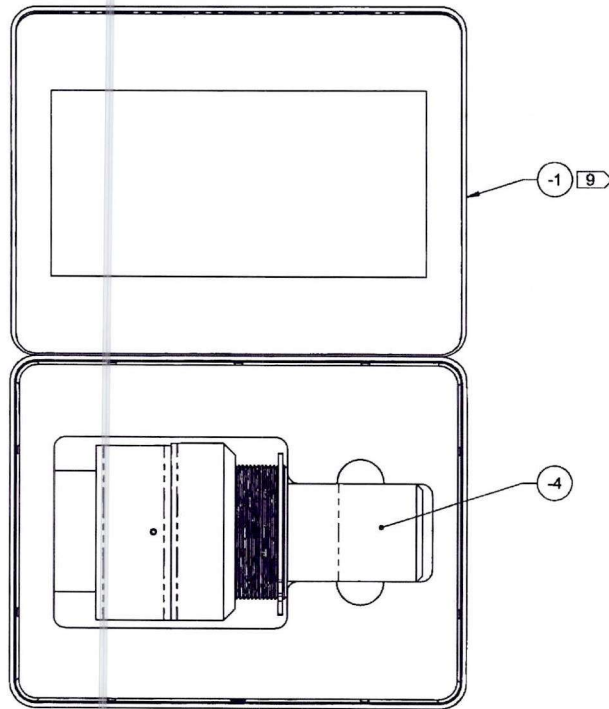
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	97524A032	8	526	0
	APP-1200-E	2	19	0
	RB 92700-10308-041-2	2	2	0
	RB 92700-10308-041-3	2	2	0
	RB 92700-10308-041-4 Rev-PO	2	0	0
	RB41011	2	423	0

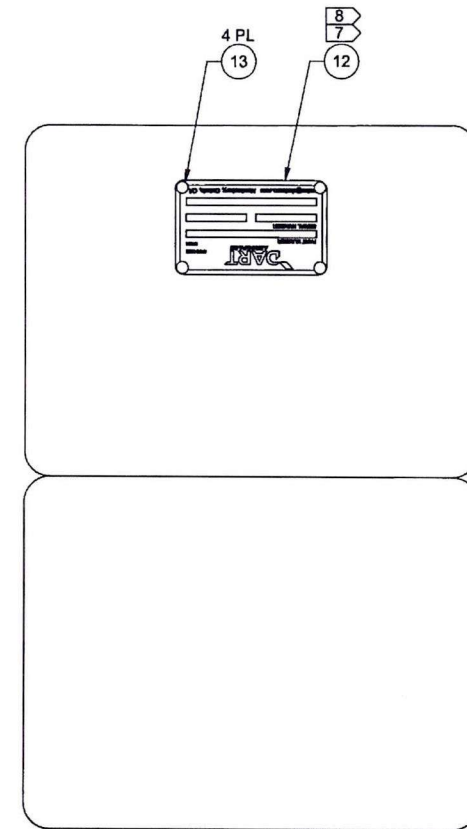
Part Specifications
Specifications could not be found.

Plex 2/7/19 8:54 AM Dart.Macdonald.Dara

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10308-041-1	PACKAGING ASSY
-4	1	RB 92700-10308-041-4	INPUT MODULE SEAL INSTALLER ASSY
12	1	RB41011	DART PLACARD
13	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RB 92700-10308-041 INPUT MODULE SEAL INSTALLER

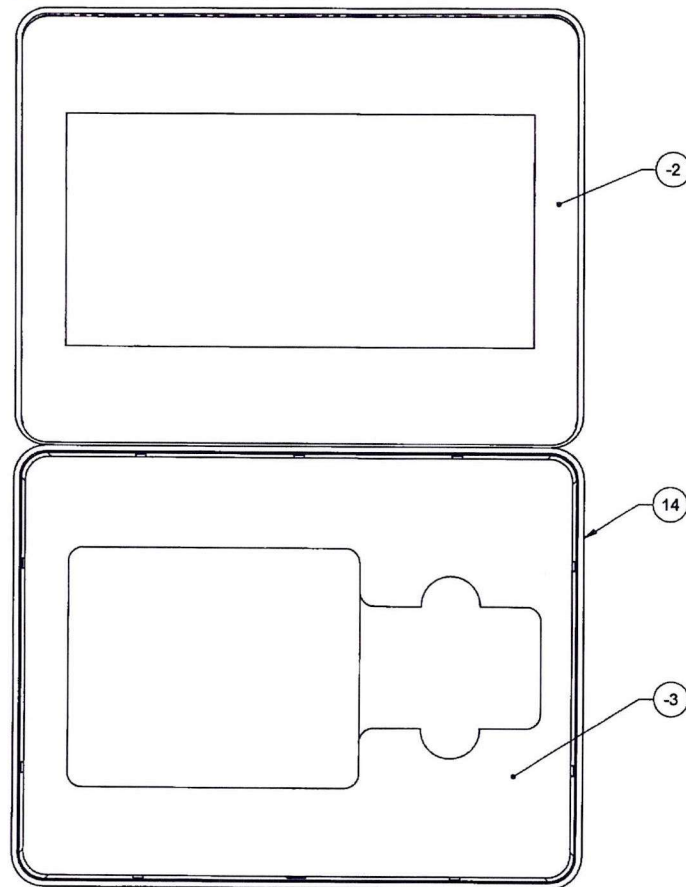


NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

A	NEW ISSUE	18-632	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 1 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RB 92700-10308-041-2	TOP FOAM
-3	1	RB 92700-10308-041-3	BOTTOM FOAM
14	1	PELICAN #APP-1200-E	PELICAN CASE 1200



RB 92700-10308-041-1 PACKAGING ASSY

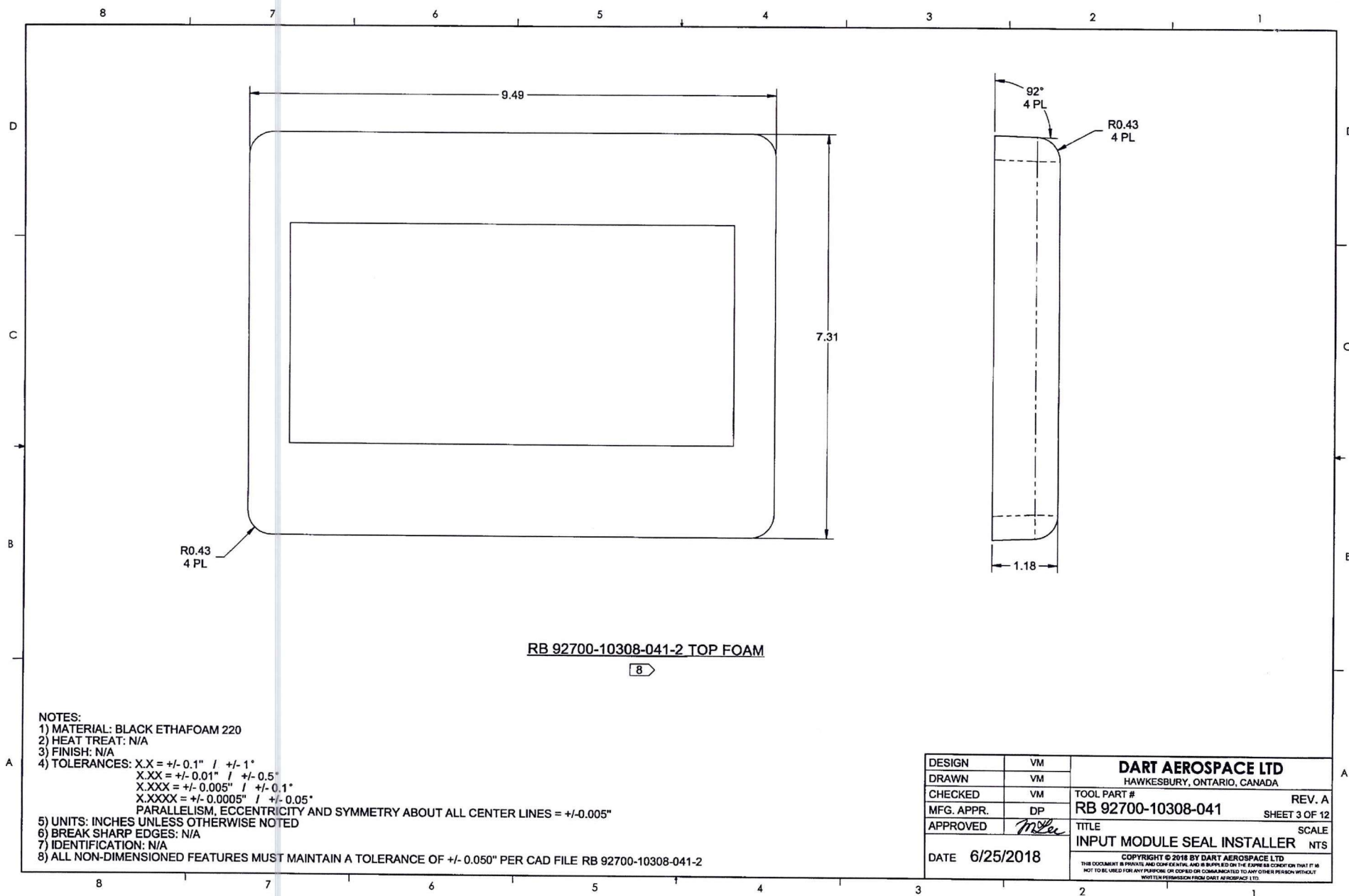
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 2 OF 12
APPROVED	<i>MLC</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE	6/25/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RB 92700-10308-041-2 TOP FOAM

8

NOTES:

- 1) MATERIAL: BLACK ETHAFOAM 220
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

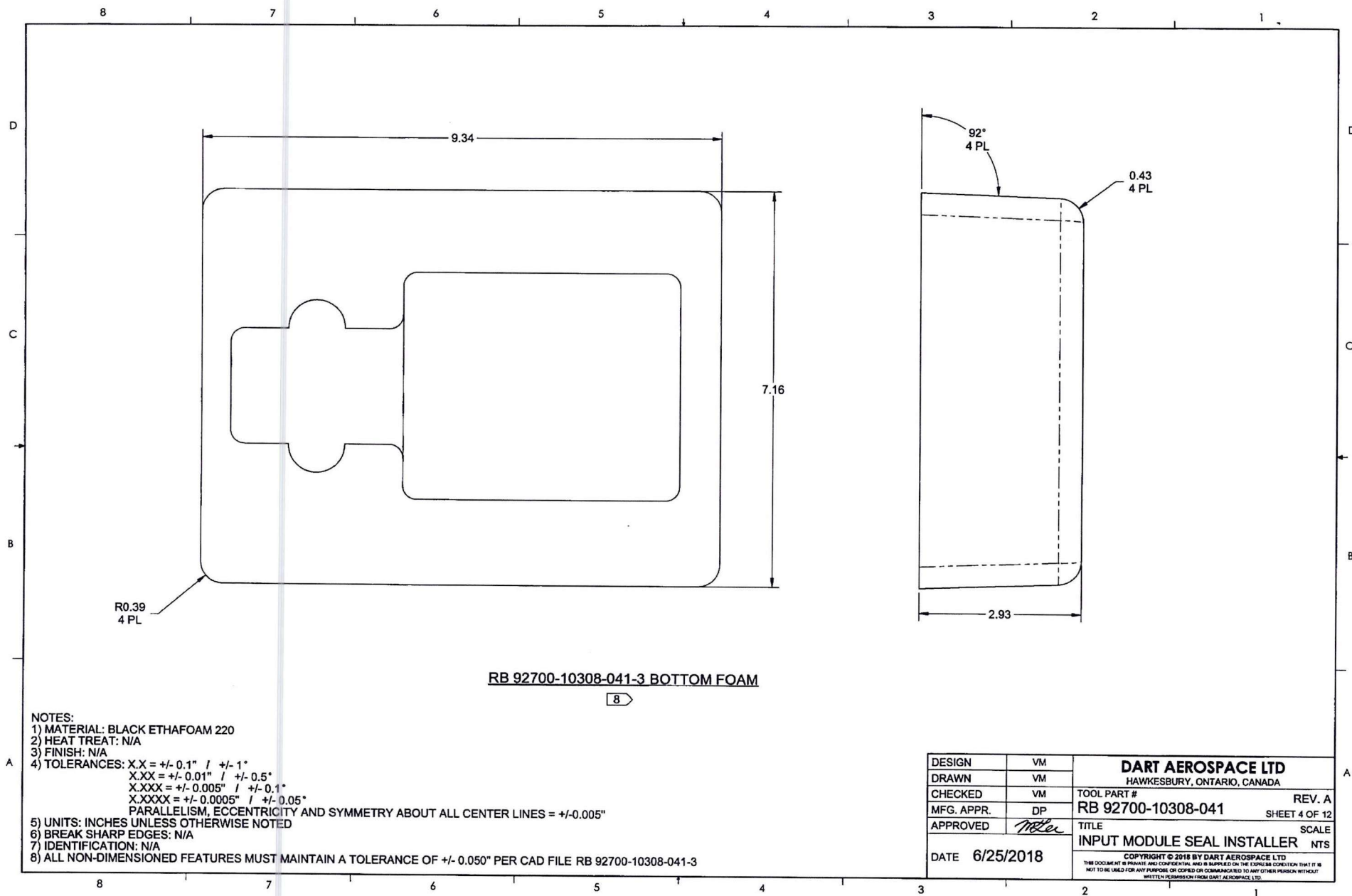
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

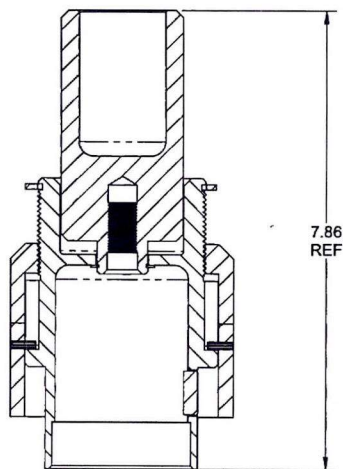
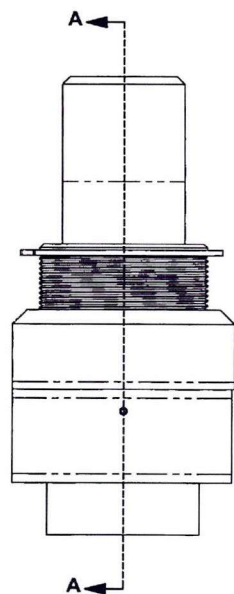
7) IDENTIFICATION: N/A

8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.050" PER CAD FILE RB 92700-10308-041-2

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 3 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-5	1	RB 92700-10308-041-5	PUSHER
-6	1	RB 92700-10308-041-6	SEAL INSTALLER ASSY
-9	1	RB 92700-10308-041-9	ALIGNMENT RING ASSY
-11	1	RB 92700-10308-041-11	THREADED RING
15	1	McMaster#97633A475 OR EQUIV	EXTERNAL RETAINING RING FOR 2-7/8" OD.
16	1	McMaster#97633A270 OR EQUIV	STEEL EXTERNAL RETAINING RING FOR 7/8" OD.



SECTION A-A

RB 92700-10308-041-4 INPUT MODULE SEAL INSTALLER ASSY 9

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

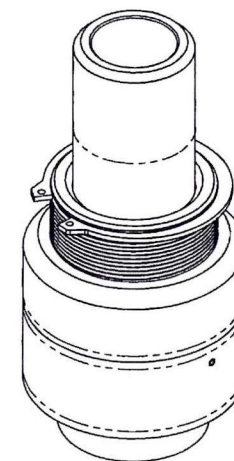
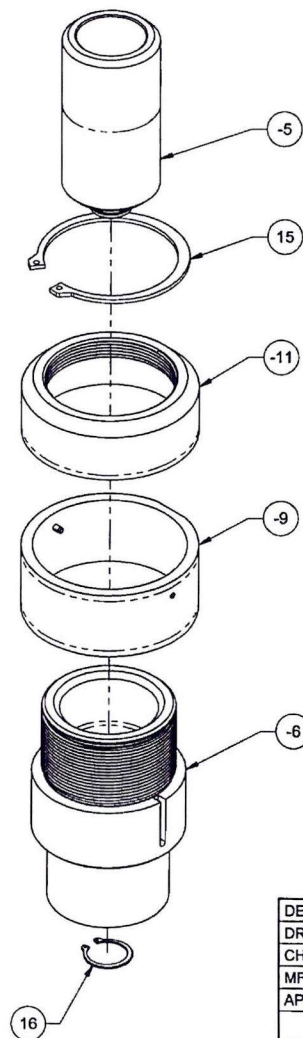
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED

- 6) BREAK SHARP EDGES: N/A

- 7) IDENTIFICATION: N/A

- 8) ASSEMBLE AS SHOWN

- 9) THE TOOL MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 5 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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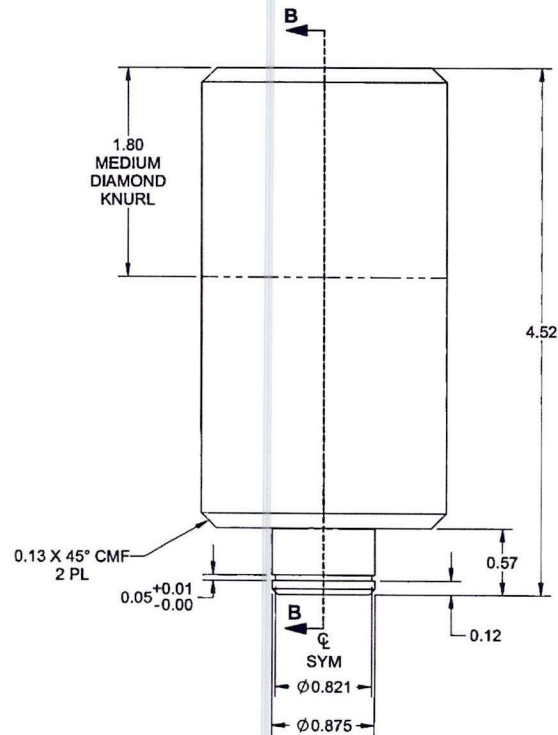
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D

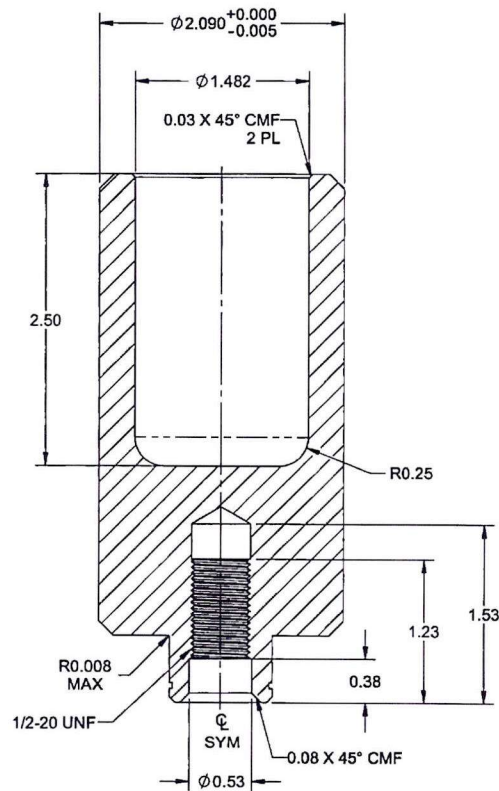
C

B

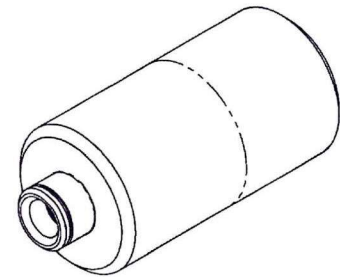
A



RB 92700-10308-041-5 PUSHER



SECTION B-B



D

C

B

A

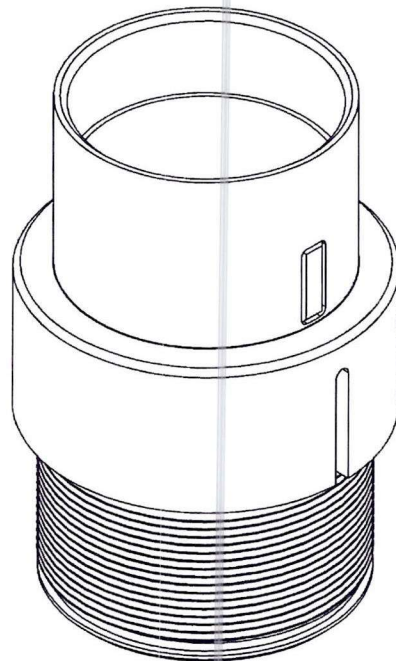
NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

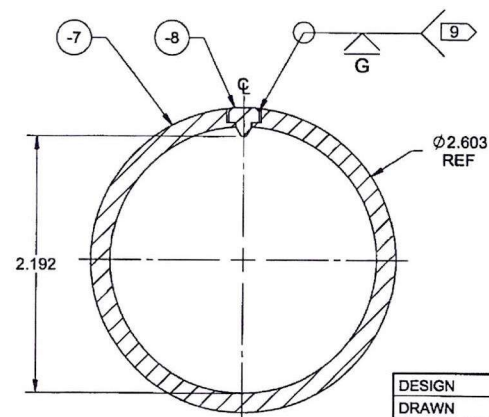
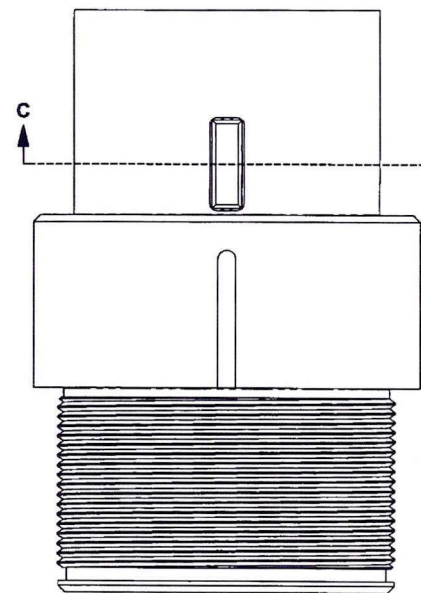
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 6 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
DATE 6/25/2018		INPUT MODULE SEAL INSTALLER	NTS
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8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-7	1	RB 92700-10308-041-7	SEAL INSTALLER
-8	1	RB 92700-10308-041-8	GEAR ALIGNMENT



RB 92700-10308-041-6 SEAL INSTALLER ASSY

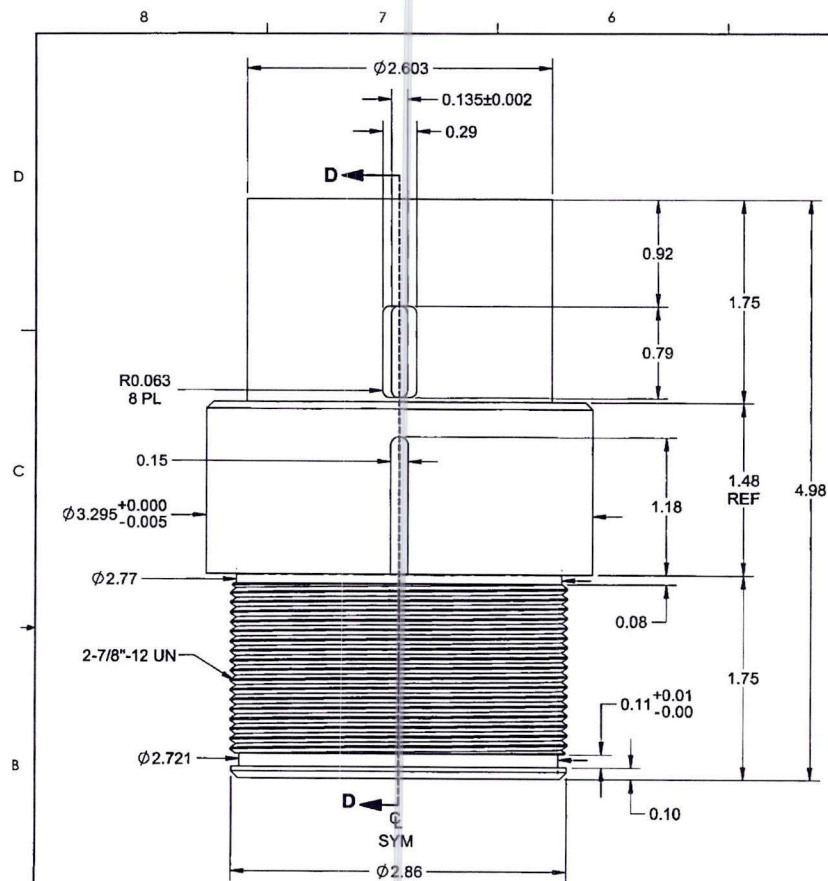


SECTION C-C

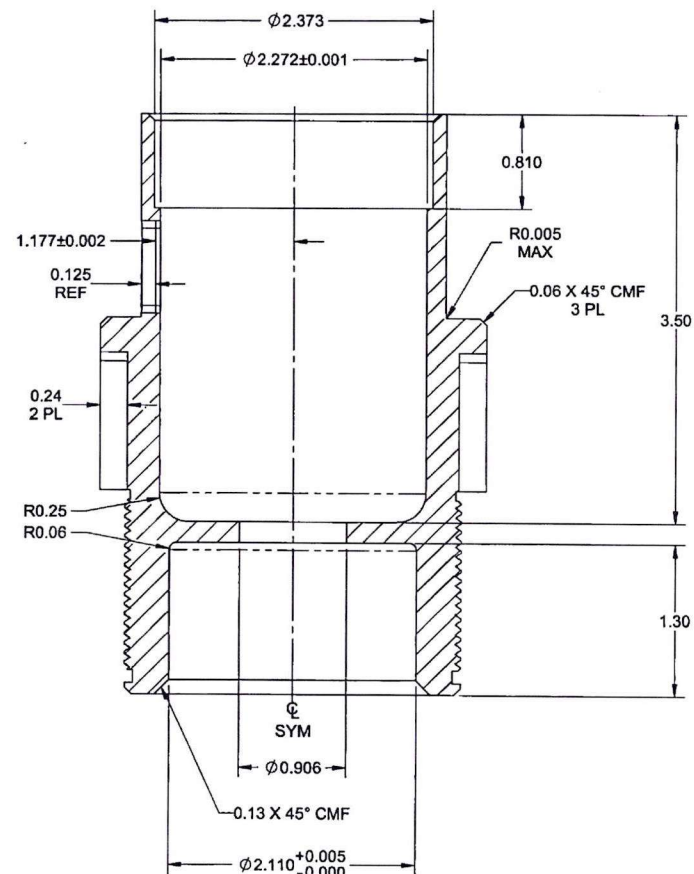
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) GRIND OR MACHINE WELD FLUSH TO SURFACE OF ITEM -7

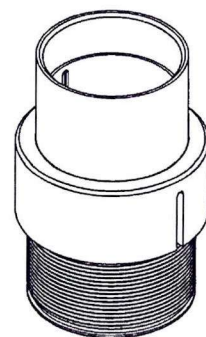
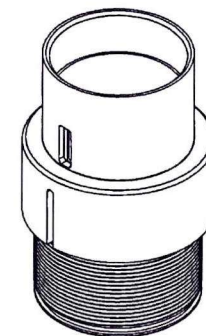
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 7 OF 12
APPROVED	<i>Moe</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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RB 92700-10308-041-7 SEAL INSTALLER



SECTION D-D



NOTES:

1) MATERIAL: 4140/4142 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"

X.XXX = +/- 0.005" / +/- 0.1"

X.XXXX = +/- 0.0005" / +/- 0.05"

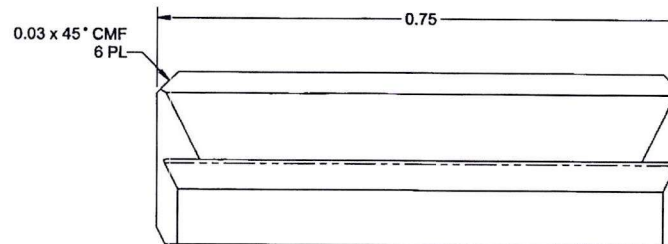
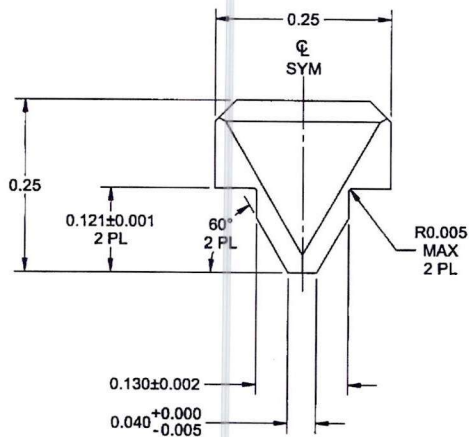
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

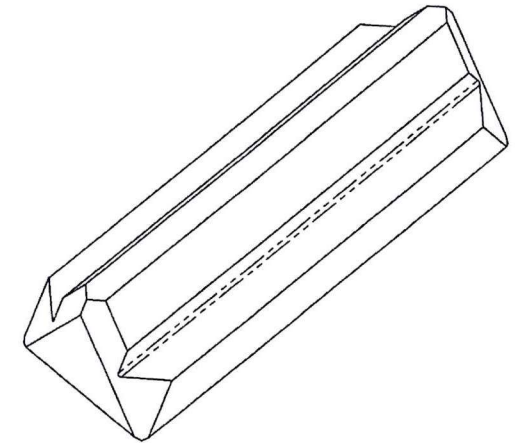
6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 8 OF 12
APPROVED	<i>McLee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE	6/25/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



RB 92700-10308-041-8 GEAR ALIGNMENT



NOTES:

- 1) MATERIAL: 4140/4142 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

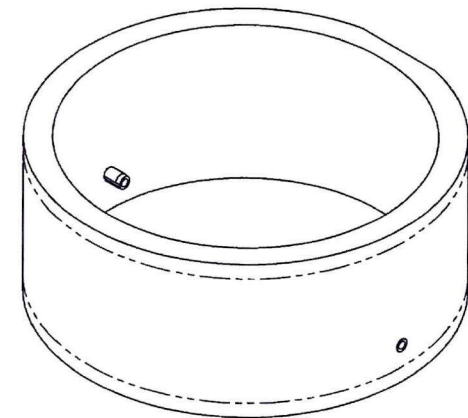
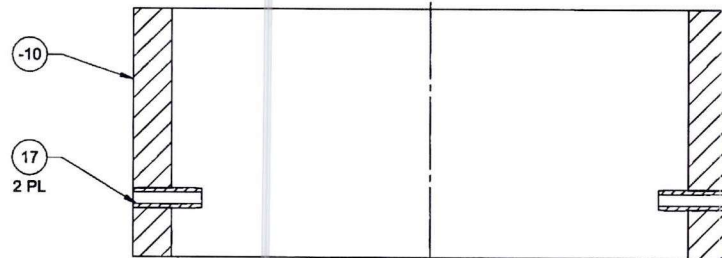
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 9 OF 12
APPROVED	<i>MPL</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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ITEM #	QTY	PART #	PART TITLE
-10	1	RB 92700-10308-041-10	ALIGNMENT RING
17	2	McMaster#90692A693 OR EQUIV	STEEL SPRING PIN 1/8" DIA. x 7/16" LG.



RB 92700-10308-041-9 ALIGNMENT RING ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

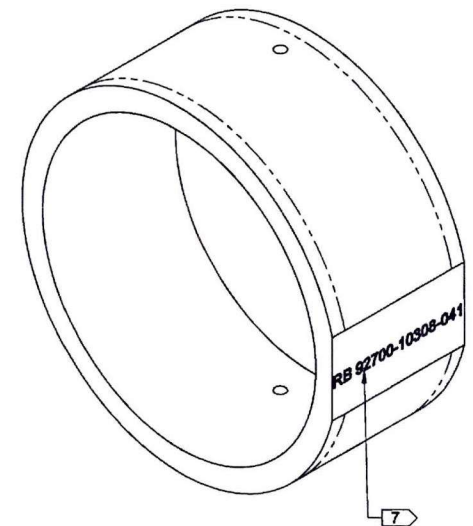
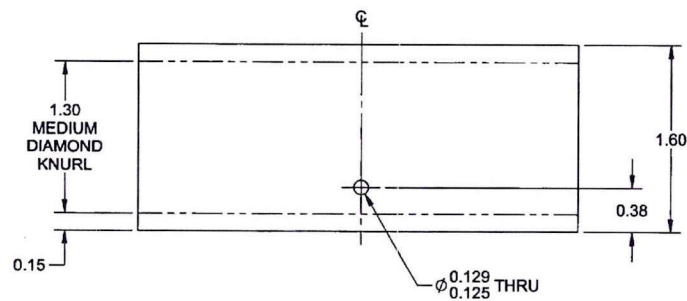
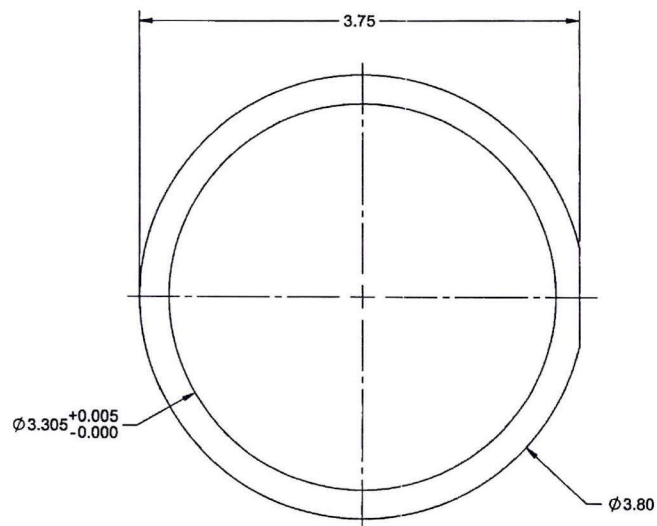
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: N/A

7) IDENTIFICATION: N/A

8) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 10 OF 12
APPROVED	<i>TRC</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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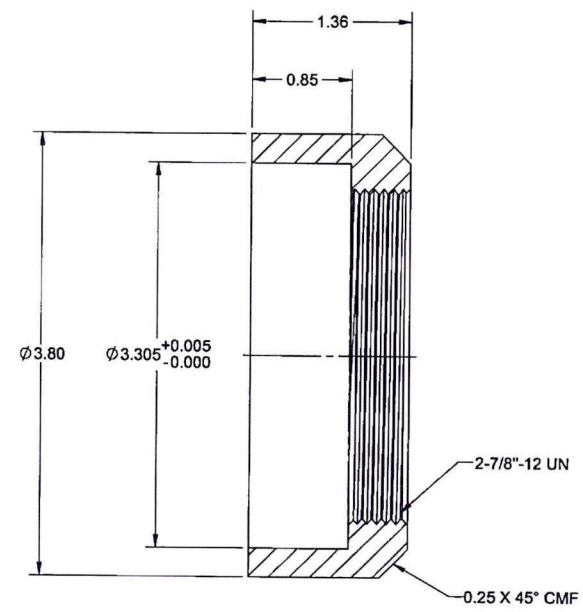
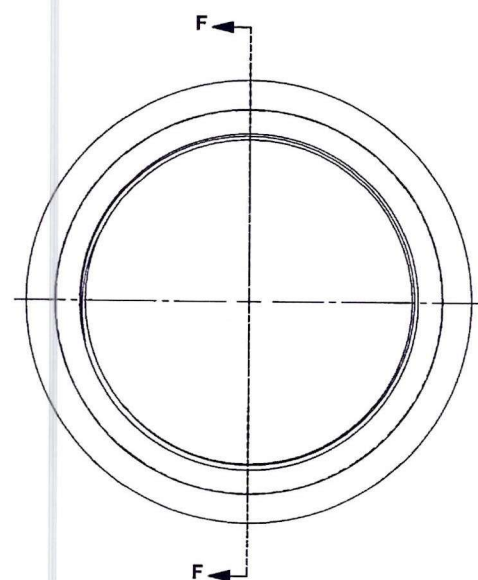
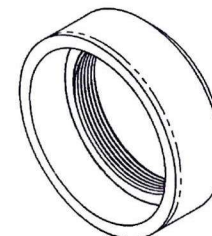
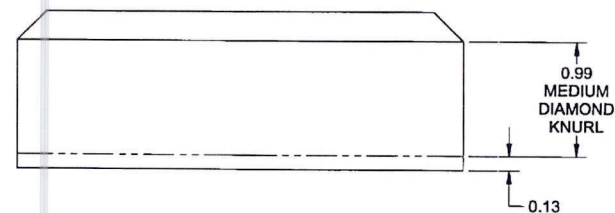


NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

RB 92700-10308-041-10 ALIGNMENT RING

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 11 OF 12
APPROVED	<i>M. Lee</i>	TITLE	SCALE
		INPUT MODULE SEAL INSTALLER	NTS
DATE	6/25/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



SECTION F-F

RB 92700-10308-041-11 THREADED RING

- NOTES:
- 1) MATERIAL: 4140/4142 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: X.X = ± 0.1 / ± 1
 X.XX = ± 0.01 / ± 0.5
 X.XXX = ± 0.005 / ± 0.1
 X.XXXX = ± 0.0005 / ± 0.05
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005" TO 0.010"
 - 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10308-041	SHEET 12 OF 12
APPROVED	<i>MtL</i>	TITLE	SCALE
DATE	6/25/2018	INPUT MODULE SEAL INSTALLER	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					